

Date: Monday, 31/03/2008 1:46:52 PM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 38254		
Estimate Number	: 12712		
P.O. Number	:	Part Number	: D35371
This Issue	: 31/03/2008 S.O. No. :	Drawing Number	: D3537 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : SMALL/MED FAB	Drawing Revision	: C
Previous Run	: 37749	Material	:
Written By	: <u>31.03.08</u>	Due Date	: 07/04/2008 Qty: 16 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07-02-14 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S16GA	304/316 .063 Sheet
-----	-----------	--------------------



2.7



Comment: Qty.: 0.1113 sf(s)/Unit Total : 1.7808 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 107513 B 8-3-31

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C

Prog Rev: C

B 8-3-31

(24)

2-Deburr if necessary B 8-3-31

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



B 8-3-31



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 02/04/08 (24)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

SB 07/04/08 (24)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 38254

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description  
A/R 2059B Hardcoat

Batch

M107051

(24)

JP

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

08-04-02

SP

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



PD 08-04-03



Comment: VISUAL INSPECTION OF GROUND WELDS

08/04/02

(X24)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S

08/04/02

(X24)

9.0

POWDER COATING

POWDER COATING



M 100442



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

JP 08-04-02

(24)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JP



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-02

(X24)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-26

JP

08-04-02

(X24)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08-04-03

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38254
<b>Description:</b> Wearpad		<b>Part Number:</b> D3537-1
<b>Inspection Dwg:</b> D3537 <b>Rev:</b> C		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

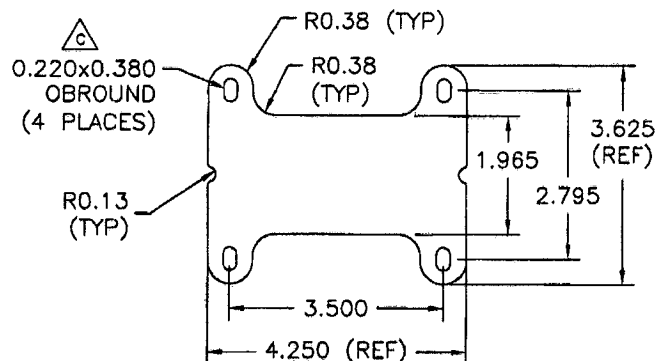
☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.246	*			
3.500	+/-0.010	3.500	*			
1.965	+/-0.010	1.964	*			
2.795	+/-0.010	2.795	*			
3.625	+/-0.010	3.623	*			
0.220 x 0.380	+/-0.010	0.226 X .385	*			

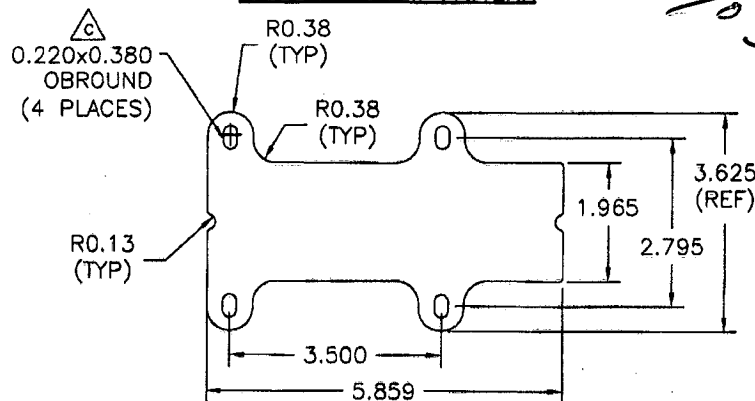
<b>Measured by:</b> JB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-3-31	<b>Date:</b> 08/04/01	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM [Signature]	[Signature]

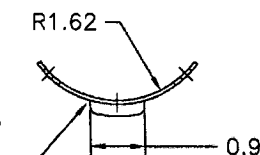
### D3537-1F FLAT PATTERN



### D3537-3F FLAT PATTERN

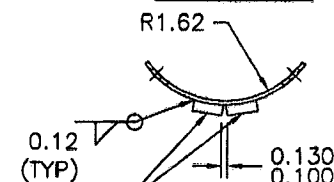


### SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

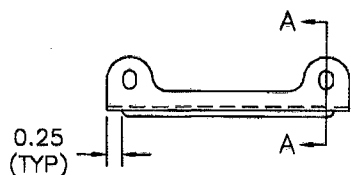
### SECTION B-B



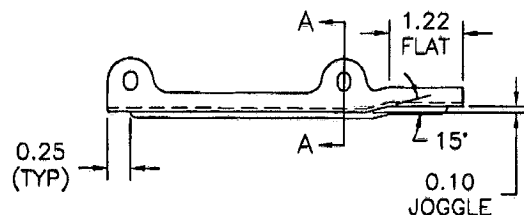
D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

**RELEASED**  
02.05.08 Ad  
per ECU  
962

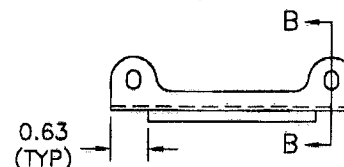
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



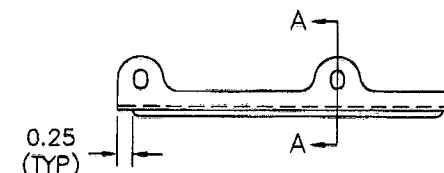
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY P.H.
CHECKED	#	APPROVED #
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		REV. C SHEET 1 OF 1 SCALE 1:2

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, MA